Each

Dart Aerospace Ltd. Tuesday, 8/28/2007 3:22:52 PM Date: Kim Johnston **Process Sheet** : CROSSBOLT SPACER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 34309 : 10329 **Estimate Number** : D2743 **Part Number** P.O. Number : NIA : D2743 REV B **Drawing Number** : 8/28/2007 S.O. No. : 1) A This Issue : N/A Prsht Rev. : NC Project Number : MACHINED PARTS : B **Drawing Revision** First Issue :NA : 32656 Material Previous Run : 9/21/2007 Due Date Written By Checked & Approved By Reformat; removed tumble and deburr step K : Est E Comment J/JLM **Additional Product** Job Number: Description: Seq. #: 6061-T6 Tube .625 x.065W M6061T6T0625W065 1.0 Comment: Qty.: 0.2800 f(s)/Unit Total: 56.0070 f(s) Material: 6061-T6 (WW-T-700/6) Ø0.625 " x 0.065" wall (M6061T6T0.625W.065) Batch: HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA202 and Dwg D2743 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 Comment: SECOND CHECK PACKAGING RESOURCE #1 5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



200

20%

-4.1.10	. oopass _								
W/O:			WC	RK ORDER CHANG	GES			****	
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						:			
						<u> </u>			
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A: <u>£</u>	Date: _	04/10/09
					QA:	N/C Close	d:	Date:	
NCR:	,	,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section E			Veritic		ation Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti	Section C	Chief Eng	QC Inspector
	•								
							W-12-1-1		
								-	

Dąte:

Tuesday, 8/28/2007 3:22:52 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 34309

Part Number: D2743

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

	-								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	By Date, Qty			Approval QC Inspector	
						•			
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes I	No DQA :	Date: _		
					QA: N/	C Closed:	Date: _		
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC	Description of NC Corrective Action		on B	Verification	Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
		•							
								1	

DART AEROSPACE LTD	Work Order:	34309
Description: Cross Bolt Spacer	Part Number:	D2743
Description cross 25% space.		
Inspection Dwg: D2743 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	L	X First A	rticle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.085	+0.030/-0.000	3.108				
Ø0.625	+/-0.010	0.625_				
0.050 x 45°	+/-0.010 x 45°	0.05×45°				
0.065	+/-0.010	0.063	/			
			-			
-						***************************************
			-			

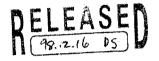
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07/10/04	Date: 07/10/07	Date:	N/A

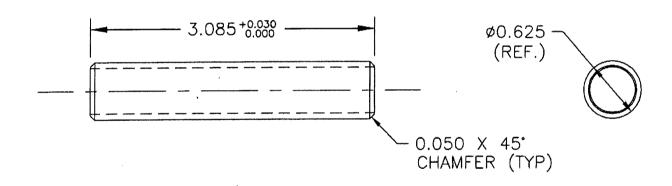
Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue	KJ/RF	1
В	06.11.20	Tolerance +/-0.010 x 45° was 0.48 x 45°	KJ/JLM	





DESIG	#	DRAWN BY	DART AEROSPACE BELLEVUE, WA	USA, INC.
CHECK	(EP	APPROVED	DRAWING NO.	REV. B
#	#	KE	D2743	SHEET 1 OF 1
DATE	······································		TITLE	SCALE
98.1	2.08		CROSS BOLT SPACER	1:1
Α		98.04.16	NEW ISSUE	
В		98.12.08	3.085 WAS 3.060	





MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL SHOP COPY TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED TO THE PROPERTY TO

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMEN

WITHOUT NOTICE

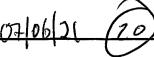
Dart Aerospace Ltd. Wednesday, 6/6/2007 1:47:36 PM User **Process Sheet Drawing Name** : LUG BRACKET : CU-DAR001 Dart Helicopters Services Customer Job Number : 32771 : 10010 Estimate Number : N/A : D27353 Part Number P.O. Number S.O. No. : NA **Drawing Number** D2735 REV C : 6/6/2007 This Issue : N/A Project Number Prsht Rev. : SMALL /MED FAB **Drawing Revision** First Issue : 31233 Material Previous Run : 6/22/2007 Qty: 20 Um: **Due Date** Written By Checked & Approved By JLM Removed from 9 Digit 05-10-25 : Est Rev:C Comment Est. C 06.07.21 waterjet EC **Additional Product** Job Number: Description: Sea. #: 1010-1025 sheet .125 M1010S125 1.0 Comment: Qtv.: 0.1733 sf(s)/Unit Total: 3.4650 sf(s)1010-1025 sheet .125 batch: MID 4 699 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2735 Dwg Rev:_ Prog Rev: 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 07/06/13 SAD Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

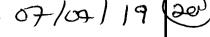
Comment: SECOND CHECK BRAKE NO NC BRAKE

Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 SB 07/04/19

2-Deburr if required.







مع

Each

Dart	Aerospace	Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No:	PAR #:	Fault Category:	NCR: Yes (No) DQA: 🔼	Date 07/08/09
	·		QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
_		Description of NC		Corrective Action Section E	 3	\/- :::: A:	Approval Chief Eng	Approval QC inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C				
······							•			

Date:

Wednesday, 6/6/2007 1:47:36 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 32771

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FINAL INSPECTION/W/O RELEASE



8.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



L07/08/07

Dart Aerospa	ice Ltd
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Pault Category: No	CR: Yes	No DQ	A :	_ Date: _	
			QA:	N/C Close	d:	Date: _	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
							Constant	
		•						
								_

DART AEROSPACE LTD Work Order: 32771

Description: Lug Bracket Part Number: D2735-3

Inspection Dwg: D2735 Rev: C Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

						1
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.41	+/-0.030	0,408	/		Very	
6.594	+/-0.010	6,002	/		Vari	
R0.63	+/-0.030	R0.63			R-6	
- 1.750	+/-0.010	1.799	V		Vern	
Ø0.438	+0.006/-0.001	\$ 0.441	/		Vern	
1.50	+/-0.030	1,494	V		height gags	-
R1.00	+/-0.030	R1.00	V		Vě-E	
1.50	+/-0.030	1.51			Vern	
0.125	+/-0.010	0.119			Vern	
			·			
				-		

Measured by:	SAD	Audited by: 💭	Prototype Approval:	N/A
Date:	0710613	Date: 07/06/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.08.29	New Issue	KJ/JLM 🚓	

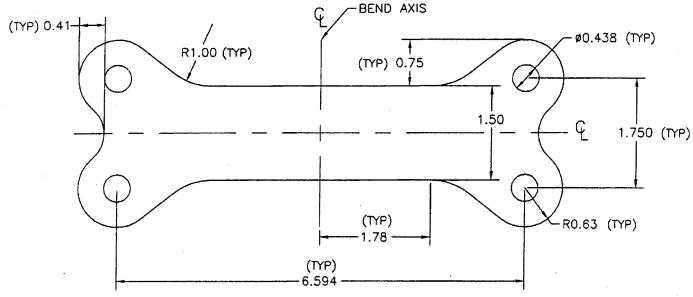




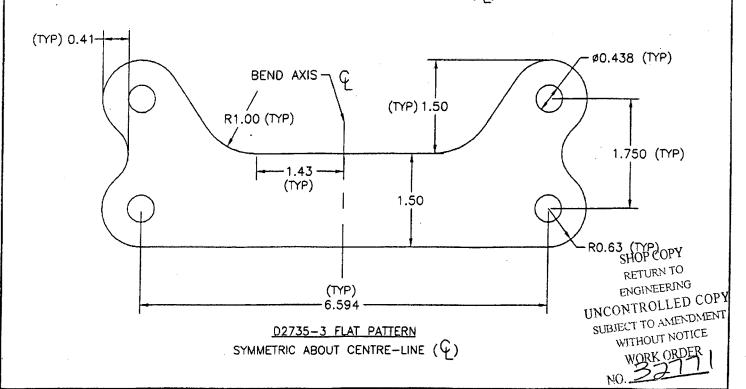
DESIG	#	ORAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	P	APPROVED KE	DRAWING NO. REV. 0 D2735 SHEET 1 OF 2
DATE			TITLE SCALF
 98.1	2.14		LUG BRACKET 2:3
Α		97.12.14	NEW ISSUE
В		98.10.23	UPDATE MATERIAL (TSR A1114)

RELEASED

Α	97.12.14	NEW ISSUE
8	98.10.23	UPDATE MATERIAL (TSR A1114)
С	98.12.14	REMOVE TOOLING HOLES (TSR A1040)

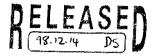


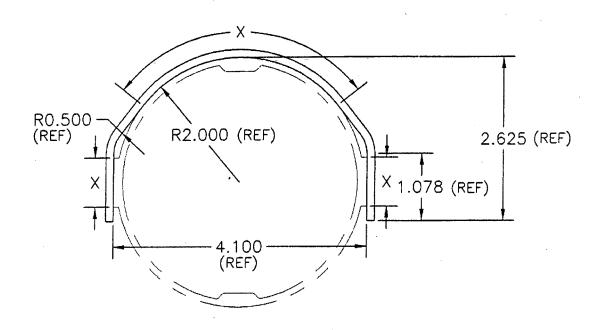
D2735-1 FLAT PATTERN SYMMETRIC ABOUT BOTH CENTRE-LINES (φ)





DESIGN	DRAWN BY	DART AERO: HAWKESBURY, OH	- -
CHECKED	APPROVED KE	ORAWING NO. D2735	REV. C SHEET 2 OF 2
DATE	1 4 3	TITLE	SCALE
98.12.14	•	LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL MATERIAL:

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SHOP COPY ALL DIMENSIONS ARE IN INCHES

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